

## Process Sheet

SPCIT-2

Date: Monday, 2/5/2007 8:07:00 AM  
User: Kim Johnston

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 30593	Part Number	: D2572
Estimate Number	: 10531	Drawing Number	: D2572 REV E
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 2/5/2007	Drawing Revision	: E
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 2/15/2007
Previous Run	: 30213	Qty:	3
Written By	: <u>JA 07.02.05</u>	Um:	12
Checked & Approved By	: <u>JA 07.02.05</u>	Each	
Comment	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & Incorporated D2572 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	D6101005	7075-T7351 8.25X5.0X2.5



Comment: Qty: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2572

Ensure that grain is along 5.00" length

Batch No: 25352

MS 07/04/19

3

BG 07.02.11

7

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 30593 Double check by: JF - J.L

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove shap edges.

MS 07/04/20 / En 07/04/23 (X3)

97/18 07.02.11 / 16 9

3.0	MILLING CONV	CONVENTIONAL MILLING MACHINE
-----	--------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

MS 07/03/23 (X3)

97/18 07.02.11 / 15 9

4.0	Q02	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 07/04/20 / En 07/03/23 (X3)

97/18 07.02.11 / 14 9





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 30593

Part Number: D2572

Job Number



Seq. #:

Machine Or Operation:

Description:

50

Q08

SECOND CHECK



Comment: SECOND CHECK

SA 07.04.23

60

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FD

07/04/23 (3)

70

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

YJ

07-04-23

(3)

80

Q03

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/04/24 (3)

90

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/04/24 (3)

100

Q021

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SA 07/04/24

(3)

Completion



u 07.04.24





DART AEROSPACE LTD		Work Order:	30543
Description: Saddle, Fwd Inboard		Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.746	1.749	1.747		
C	3.495	3.505		3.500	3.500	3.499	3.500		
D	1.745	1.755		1.749	1.746	1.749	1.747		
E	7.990	8.010		8.001	8.001	7.999	8.001		
F	0.490	0.510		0.501	0.497	0.497	0.495		
G	0.257	0.262	DT8683	0.259	0.258	0.260	0.266		
H	0.375	0.380	DT8684	0.376	0.378	0.378	0.378		
I	0.490	0.510		0.500	0.495	0.493	0.497		
J	1.174	1.184		1.178	1.178	1.176	1.178		
K	0.558	0.578		0.568	0.566	0.566	0.568		
L	1.174	1.184		1.178	1.178	1.176	1.178		
M	1.490	1.500		1.495	1.493	1.494	1.493		
N	2.495	2.505		2.500	2.496	2.497	2.496		
O	3.869	3.879		3.871	3.872	3.875	3.873		
P	0.115	0.135		0.127	0.134	0.123	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.253	0.252	0.249		
S	0.115	0.135		0.129	0.125	0.124	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.238	0.238	0.240	0.233		
W	0.115	0.135		0.129	0.135	0.132	0.131		
X	0.307	0.312		0.310	0.311	0.310	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.364	0.365	0.369		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.625	0.624	0.626		
AC	0.053	0.073		0.063	0.062	0.063	0.063		
AD	0.240	0.260		0.249	0.248	0.246	0.249		
AE	1.375	1.395		1.379	1.385	1.388	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.266	0.260	0.260	0.260		
AH	0.240	0.260		0.251	0.250	0.251	0.249		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	MS / ES	Audited by:	SA
Date:	07/04/14 / 07/04/13	Date:	07/04/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

